

Ship Thru's latest 2/02

Work Order ID 97387

\*97387\*

Page 1

February-19-13 9:58:38 AM

Item ID: D3703-5

Accept

\*N900040100\*

Setup Start \*NS1\*

Revision ID:

Stop \*NS2\*

Item Name: Aft Cap

Start Date: 2/19/13

Start Qty: 12.00

\*12\*

Cust Item ID:

Required Date: 2/20/13

Req'd Qty: 12.00

\*12\*

Customer:

Reference:

Approvals:

Process Plan:

*W*

Date:

Tooling:

Date:

Run Start \*NR1\*

QC:

Date:

SPC (Y/N):

Date:

Stop \*NR2\*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
--------------------------------	--------------------------	----------------------	---------	--------	--------------	---------------	---------------	------------------	----------------

Draw Nbr

Revision Nbr

D3703

B

100

0.00

\*100\*

FLOW WATER JET

Waterjet

Memo

0.00

FLOW CNC Waterjet

1-Cut as per Dwg D3703

6061.063

Dwg Rev: B

Prog Rev: B

2- Deburr if necessary

12 0 Jm 13-2-19

110

QC2- Inspect parts off machine FAI/FAIB

0.00

\*110\*

QC

Memo

0.00

Quality Control

12 0 Jm 13-2-19

# Work Order ID 97387

February-19-13 9:58:38 AM

**\*97387\***

Page 2

Item ID: D3703-5 Accept **\*N900040100\*** Setup Start **\*NS1\***  
Revision ID: Stop **\*NS2\***  
Item Name: Aft Cap  
Start Date: 2/19/13 Start Qty: 12.00 **\*12\*** Cust Item ID:  
Required Date: 2/20/13 Req'd Qty: 12.00 **\*12\*** Customer:  
Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_ Run Start **\*NR1\***  
QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_ Stop **\*NR2\***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120 <b>*120*</b> QC Quality Control	QC8- Inspect parts - second check  Memo	0.00 0.00 Shp 13.2.20				12			
130 <b>*130*</b> HandFinish Hand Finishing	Chemical Conversion Coat per QS1005 4.1  Memo	0.00 0.00				12		76 13.2.20	
140 <b>*140*</b> QC Quality Control	QC7-Inspect Chemical Conversion Coat  Memo	0.00 0.00 CAS 15 2.93 13.2.20				12			

**Work Order ID 97387**

February-19-13 9:58:38 AM

**\*97387\***

Page 3

Item ID: D3703-5

Accept

**\*N900040100\***Setup Start **\*NS1\***

Revision ID:

Stop **\*NS2\***

Item Name: Aft Cap

Start Date: 2/19/13

Start Qty: 12.00

**\*12\***

Cust Item ID:

Required Date: 2/20/13

Req'd Qty: 12.00

**\*12\***

Customer:

Reference:

Approvals: Process Plan: \_\_\_\_\_ Date: \_\_\_\_\_ Tooling: \_\_\_\_\_ Date: \_\_\_\_\_

Run Start **\*NR1\***

QC: \_\_\_\_\_ Date: \_\_\_\_\_ SPC (Y/N): \_\_\_\_\_ Date: \_\_\_\_\_

Stop **\*NR2\***Sequence ID/  
Work Center IDOperation  
DescriptionSet Up/  
Run HoursTool ID Tool # Plan  
Code Accept Reject Reject Insp.  
Qty Qty Number Stamp

150

Identify as per dwg & Stock Location: STC63 0.00**\*150\***

Packaging

Memo

0.00

Packaging

Dx SP  
13-2-20

160

QC21- Final Inspection - Work Order Release

0.00

**\*160\***

QC

Memo

0.00

Quality Control

MCS 13-02-2113-02-21

# Picklist Print

February-19-13 9:58:38 AM

Page 1

Work Order ID: 97387

Parent Item: D3703-5

Parent Item Name: Aft Cap

Start Date: 2/19/13

Required Date: 2/20/13

Start Qty: 12.00

Required Qty: 12.00

Comments: IPP Rev:A 08-04-24 new issue DD verified by:EC

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
M6061T6S.063 6061-T6 .063 Sheet		Purchased	No			100	sf	296.1625	0.08	<del>1.0105263</del> 1.2		Jan 13 2-19	

Location

Loc Qty

Loc Code

MAT021

296.1625

123135

120.5625

124003

175.6

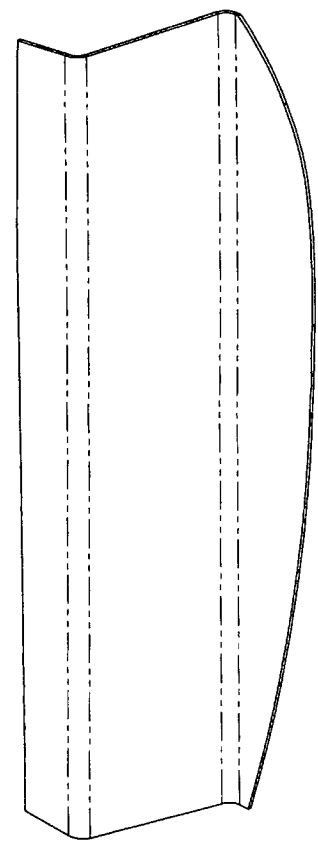
124003



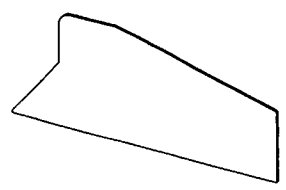
8 7 6 5 4 3 2 1

D  
C  
B  
A

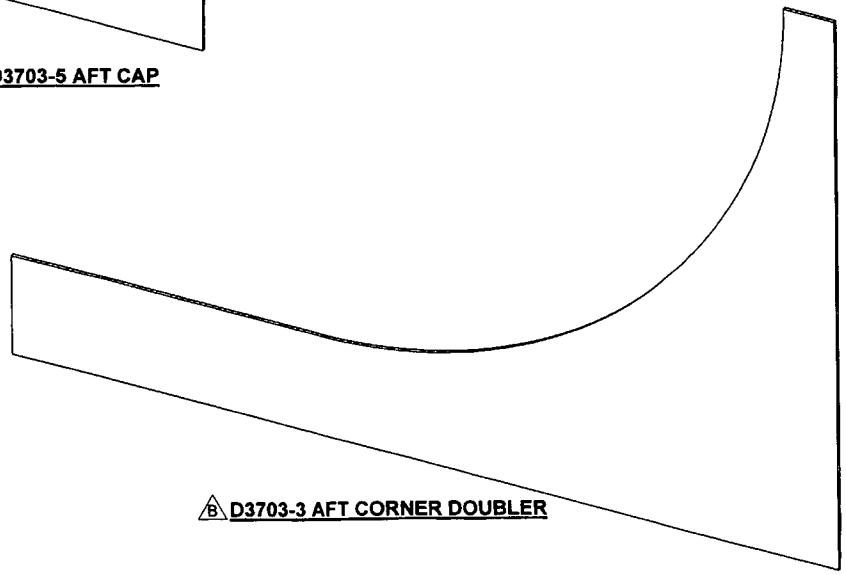
D  
C  
B  
A



8 D3703-1 AFT DOUBLER



B D3703-5 AFT CAP



B D3703-3 AFT CORNER DOUBLER

u/697387

RELEASED  
2013-01-14  
m

- NOTES:
- 1) MATERIAL: 6061-T6 (OR 6061-T62) ALUMINUM SHEET, 0.063 THICK  
PER AMS-QQ-A-250/11 OR AMS 4025 OR AMS 4027  
(REF. DART SPEC. M6061T6S.063)
  - 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
  - 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
  - 4) UNITS: INCHES UNLESS OTHERWISE NOTED
  - 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
  - 6) IDENTIFICATION: IDENTIFY WITH DART P/N "D3703-X" AND B/N "BXXXXX" PER DART QSI 044 6.1 (PERMANENT PAINT MARKER)
  - 7) WEIGHT: D3703-1 = 0.56 lbs, D3703-3 = 0.23 lbs, D3703-5 = 0.03 lbs
  - 8) MANUFACTURE PART FROM "D3703-1F.DXF" FILE

B	REVISED D3703-3/-5. REASON: PAR12-188/CIR12-4.	MB	12.12.06
A	NEW ISSUE	MB	08.04.30
REV.	DESCRIPTION	BY	DATE
DESIGN			
DRAWN			
CHECKED			
MFG. APPR.			
APPROVED			
DE APPR.			
DATE	12.12.06		

DART AEROSPACE LTD	
HAWKESBURY, ONTARIO, CANADA	
DRAWING NO.	REV. B
D3703	SHEET 1 OF 4
TITLE	SCALE
AFT DOUBLER	NTS
COPYRIGHT © 2008 BY DART AEROSPACE LTD	
THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.	

8 7 6 5 4 3 2 1

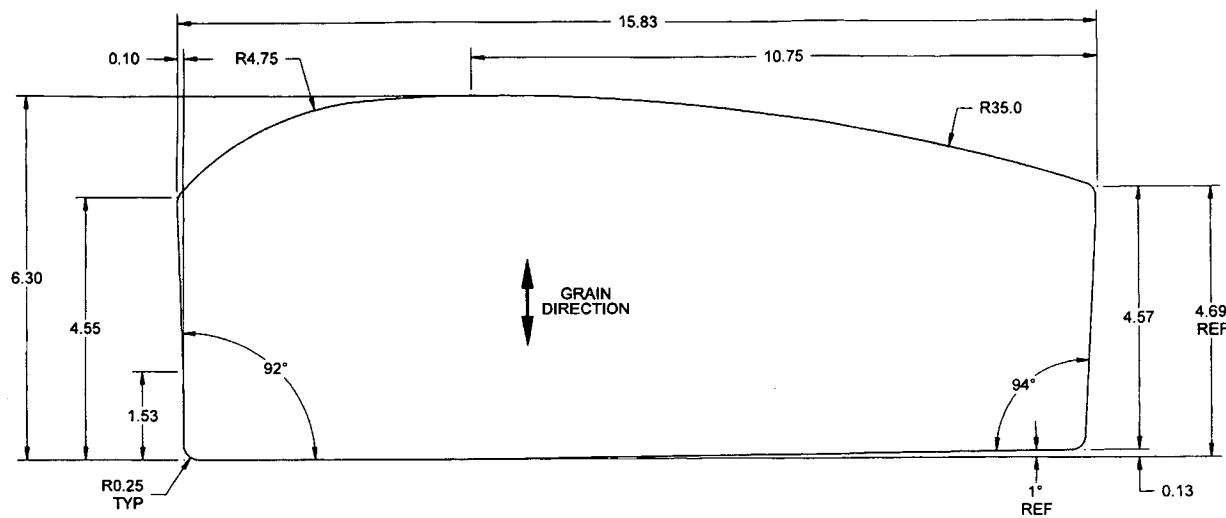
8 7 6 5 4 3 2 1

D

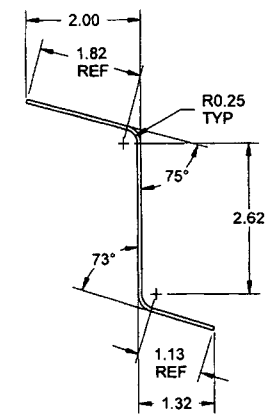
C

B

A



**D3703-1F AFT DOUBLER FLAT PATTERN**

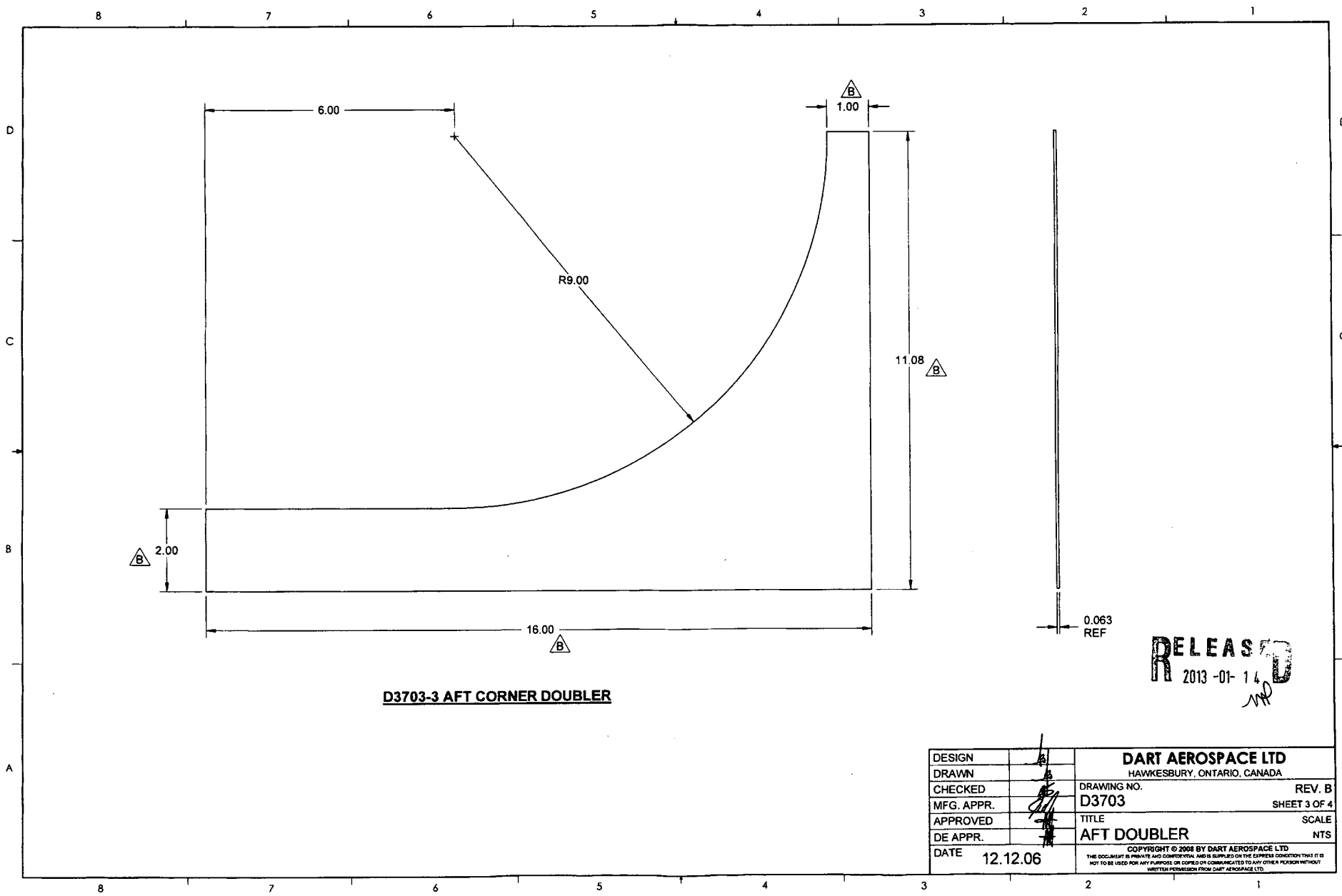


**D3703-1 AFT DOUBLER  
(MAKE FROM D3703-1F)**

**RELEASED**  
R 2013-01-14

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3703</b>	REV. B
MFG. APPR.		TITLE <b>AFT DOUBLER</b>	SHEET 2 OF 4
APPROVED		SCALE	NTS
DE APPR.		COPYRIGHT © 2008 BY DART AEROSPACE LTD	
DATE	12.12.06	THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD	

8 7 6 5 4 3 2 1

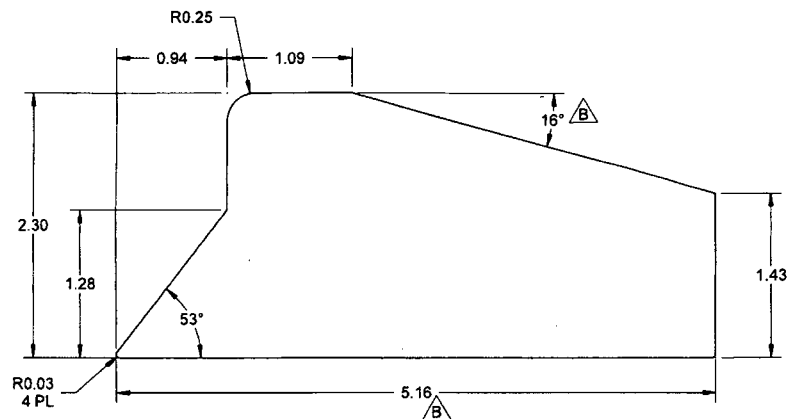


**D3703-3 AFT CORNER DOUBLER**

**RELEASED**  
2013-01-14

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. B
MFG. APPR.		<b>D3703</b>	SHEET 3 OF 4
APPROVED		TITLE	SCALE
DE APPR.		<b>AFT DOUBLER</b>	NTS
DATE	12.12.06	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	





**D3703-5 AFT CAP**

**RELEASED**  
2013-01-14  
*nd*

DESIGN		<b>DART AEROSPACE LTD</b>	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO. <b>D3703</b>	REV. <b>B</b>
MFG. APPR.		SHEET 4 OF 4	
APPROVED		TITLE	SCALE
DE APPR.		<b>AFT DOUBLER</b>	NTS
DATE	<b>12.12.06</b>	<small>COPYRIGHT © 2008 BY DART AEROSPACE LTD THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR REPRODUCED OR DISSEMINATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.</small>	